

(19) World Intellectual Property Organization  
International Bureau



(43) International Publication Date  
29 November 2001 (29.11.2001)

PCT

(10) International Publication Number  
**WO 01/90267 A2**

(51) International Patent Classification<sup>7</sup>: C09D 183/00

[JP/JP]; 4-27-8, Jinguumae, Shibuya-ku, Shibuya-ku, Tokyo 150-0001 (JP). KAKU, Mureo [JP/JP]; 2-40-7, Toyosatodai, Utsunomiya, Tochigi 320-003 (JP).

(21) International Application Number: PCT/US01/16282

(22) International Filing Date: 18 May 2001 (18.05.2001)

(74) Agent: SHAY, Lucas, K.; E.I. Du Pont De Nemours and Company, Legal Patent Records Center, 1007 Market Street, Wilmington, DE 19898 (US).

(25) Filing Language: English

(26) Publication Language: English

(81) Designated States (*national*): CA, CN, JP, KR, US.

(30) Priority Data:  
2000-148885 19 May 2000 (19.05.2000) JP  
2000-155281 25 May 2000 (25.05.2000) JP

(84) Designated States (*regional*): European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE, TR).

(71) Applicant (*for all designated States except US*): E.I. DU PONT DE NEMOURS AND COMPANY [US/US]; Legal Patent Records Center, 1007 Market Street, Wilmington, DE 19898 (US).

Published:  
— *without international search report and to be republished upon receipt of that report*

(72) Inventors; and

(75) Inventors/Applicants (*for US only*): IWATO, Satoko

*For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.*

(54) Title: EMULSION AND WATER-REPELLENT COMPOSITION

(57) Abstract: A composition having water-repellency at high temperature is provided. Some of the invention compositions also exhibits oil-repellency at high temperature. The composition comprises a fluorocarbon silane or hydrolyzate thereof; a surfactant; a polymerizable, silicon-containing compound; and a catalyst.

WO 01/90267 A2

## EMULSION AND WATER-REPELLENT COMPOSITION

5

FIELD OF THE INVENTION

The present invention relates to an emulsion composition comprising a fluorocarbon silane or hydrolyzate thereof and coated composition produced therefrom.

10

BACKGROUND OF THE INVENTION

Some silane-containing aqueous solutions that can provide water-repellent characteristics on the surface of a substrate have been disclosed. See, e.g., US patent numbers 4,648,904, 4,757,106, 4,990,377, 5,196,054, 5,550,184, and 5,664,014, European Patent 0 748 357, and Japanese Kokai Patent Application  
15 No. Hei 11(1999)-181355.

For example, U. S. Patent No. 5,550,184 discloses reactive hydrolyzed silane emulsions produced by emulsifying a hydrolyzable alkoxysilane in water in the presence of a high HLB value emulsifier to simultaneously retain the hydrolyzable alkoxysilane in substantially totally hydrolyzable state. The  
20 emulsion can produce durable coatings that impact water-repellent characteristics on a substrate.

Japanese Kokai Patent Application No. Hei 11(1999)-181355 discloses an emulsion containing a specific type of silane hydrolyzate, a specific type of silicate a substance, and a surfactant. The emulsion, however, requires pH  
25 adjustments to alkaline region in order to exhibit water-repellency and heat resistance characteristics.

Therefore, it is desirable to develop a new emulsion or coating containing the emulsion that does not require the alkaline pH adjustment to exhibit the desired heat-resistance and water-repellency properties.

30

Additionally, though these emulsions exhibit water-repellency characteristics, they do not exhibit oil-repellent property. For example, glass

window of oven, range, or toaster can be coated with a layer formed by an emulsion having good water repellency at high temperature, but it has a poor oil-stain resistance. Therefore, it is also highly desirable to develop an emulsion that can exhibit both water-repellent and oil-repellent properties for a variety of applications.

Therefore, it is desirable to develop a new emulsion or coating containing the emulsion that does not require the alkaline pH adjustment, or without the need of metal hydroxide or the chemicals disclosed above, to exhibit the desired heat-resistance and water-repellency properties.

Additionally, though these emulsions exhibit water-repellency characteristics, they do not exhibit oil-repellent property. For example, glass window of oven, range, or toaster can be coated with a layer formed by an emulsion having good water repellency at high temperature, but it has a poor oil-stain resistance. Therefore, it is also highly desirable to develop an emulsion that can exhibit both water-repellent and oil-repellent properties for a variety of applications.

### SUMMARY OF THE INVENTION

A composition comprises a fluorocarbon silane or hydrolyzate thereof; a surfactant; a polymerizable, silicon-containing compound; and a catalyst.

### DETAILED DESCRIPTION OF THE INVENTION

The fluorocarbon silane generally contains at least one hydrolyzable fluorocarbon silane and can be represented by  $R_f-(CH_2)_p-Si\{-(O-CH_2CH_2)_n-OR'\}_3$  where  $R_f$  can be one or more  $C_{3-18}$  perfluoroalkyl groups, each  $R'$  can be the same or different and is independently a  $C_{1-3}$  alkyl groups or combinations thereof,  $p = 2-4$ , and  $n = 2-10$ ). The preferred  $R_f$  is mixed perfluoroalkyl groups of 8 to 18 carbons.

Examples of the fluorocarbon silanes include, but are not limited to, perfluoroalkylethyltris (2-(2-methoxyethoxy)ethoxy)silane when  $n$  is 2, and (2-(2-(2-methoxyethoxy)ethoxy)ethoxy)silane when  $n$  is 3, and combinations thereof. These fluorocarbon silanes are either commercially available or can be produced by any means known to one skilled in the art as disclosed in Kir-Othmer Encyclopedia of Chemical Technology, 3<sup>rd</sup> edition, vol. 20. For example, the

fluorocarbon can be produced by the method disclosed in US5,550,184, disclosure of which is incorporated herein by reference.

Any surfactant that can emulsify the hydrolysis product of the fluorocarbon silane can be used. The surfactant generally is a surfactant having an HLB value sufficiently high to inhibit self-condensation of the fluorocarbon silane hydrolysis product. The term "HLB" refers to the HLB system published by ICI America's, Inc., Wilmington, Delaware; Adamson, A.W., "Physical Chemistry of Surfaces", 4<sup>th</sup> edition, John Wiley & Sons, New York, 1982). The surfactant can be anionic, cationic, nonionic, amphoteric, or combinations thereof. The preferred surfactants are those with HLB values greater than 12, more preferably greater than 16. Generally, the lower HLB value the surfactant is, the larger amount of the surfactant is required to stabilize the emulsion. Two or more miscible surfactants generally can also be combined or mixed for use as long as they are surfactants having HLB values sufficiently high to inhibit self-condensation of the fluorocarbon silane hydrolysis products.

The HLB value of a nonionic surfactant can be determined by calculation with a formula, among others, originated by Griffin of Atlas Co. (now ICI America) in the U.S. However, in the case of the anionic type or the cationic type, a method for determination by calculation of the HLB value is not available to date. Nevertheless, paying attention to the fact that changes in emulsification characteristics are sensitive to changes in the HLB value, Atlas Company established and published a method for the experimental determination of the HLB value by an emulsification experiment on standard oil. Companies other than Atlas have also established methods for experimental determination of HLB value. However, it can be clarified by the adoption of any experimental method that the HLB value of the anionic type or the cationic type is greater than 16.

Examples of nonionic surfactants include, but are not limited to,  $R'_f-CH_2CH_2-O-(CH_2CH_2O)_{11}-H$ ,  $C_9H_{19}-C_6H_4-O-(CH_2CH_2O)_{50}-H$ , other nonionic surfactants, and combinations thereof. Examples of cationic surfactants include, but are not limited to  $R'_f-CH_2CH_2SCH_2CH(OH)CH_2N(CH_3)_3^+Cl^-$ , other cationic surfactants, and combinations thereof. Examples of anionic surfactants include, but are not limited to,  $C_{12}H_{25}(OCH_2CH_2)_4OSO_3^-NH_4^+$ ,  $C_{12}H_{27}-C_6H_4-SO_3^-Na^+$ , other anionic surfactants, and combinations thereof. In each of the formulae,  $R'_f$

is a perfluoroalkyl group generally having about 3-18 carbon atoms. The preferred surfactants are nonionic surfactants having polyethylene glycol in the molecular chain.

5           The content of the fluorocarbon silane in the water-based emulsion can be about 0.1 weight % or higher, preferably about 2-20 weight %, and most preferably 7-15 weight %, based on the total weight of the emulsion. The weight ratio of the fluorocarbon silane to the surfactant can be in the range of from about 1:1 to about 10:1, preferably about 10:2 to about 10:5, and even more preferably  
10   10:3.

Any polymerizable, silicon-containing compound can be used so long as it can copolymerize with the fluorocarbon silane hydrolysis product to improve heat-resistant water-repellent characteristics, heat-resistant oil-repellent characteristics, or both. Suitable polymerizable, silicon-containing compounds  
15 include silicates, organosilanes, or combinations thereof.

A suitable silicate can have the formula of  $\text{Si-R}_4$  where R is one or more groups selected from the group consisting of  $\text{OCH}_3$ ,  $\text{OCH}_2\text{CH}_3$ ,  $(\text{OCH}_2\text{CH}_2)_m\text{OCH}_3$ , and combinations thereof in which  $m = 1-10$ , preferably 1-3. Because a silicate represented by  $\text{Si}-((\text{OCH}_2\text{CH}_2)_m\text{OCH}_3)_4$  ( $m = 1-3$ ) is  
20 water-soluble, it can dissolve in a water-based emulsion containing a fluorocarbon silane hydrolysis product in a relatively short time, the silicate represented by  $\text{Si}-((\text{OCH}_2\text{CH}_2)_2\text{OCH}_3)_4$  is presently preferred.

The silicate to the fluorocarbon silane molar ratio can be in the range of from about 0.3:1 to about 10:1, preferably 0.3:1 to 5:1, and most preferably 0.4:1  
25 to 2:1. Suitable organosilane include organoalkoxysilanes having the formula of  $\text{R}^2_q\text{Si}(\text{OR}^3)_{4-q}$  where each  $\text{R}^2$  can be independently an alkyl group having 1 to about 10 carbon number; each  $\text{R}^3$  can be the same or different and each is independently an alkyl group having 1 to about 3 carbon number; and  $q = 1-3$ . Examples of suitable organosilanes include, but are not limited to,  
30 methoxysilanes, ethoxysilanes, propoxysilanes, and combinations thereof.

The molar ratio of organoalkoxysilane to fluorocarbon silane can be in the range of from about 0.3:1 to about 10:1, preferably 0.3:1 to 5:1, and most preferably 0.4:1 to 2:1.

The catalyst can be either an acid or a pH-adjusting agent. An aqueous acid such as phosphoric acid, boric acid, hydrochloric acid, sulfuric acid, nitric acid, acetic acid, oxalic acid, or combinations thereof can be used as acid for the composition.

The presently preferred catalyst, if a silicate is used as silicon-containing compound, is phosphoric acid, boric acid, or combinations thereof.

If an organosilane is used as the silicon-containing compound, the aqueous solution of the above-disclosed acid or aqueous alkaline solution such as ammonia, pyridine, sodium hydroxide, or potassium hydroxide, can be used as catalyst. Aqueous phosphoric acid solution is especially suitable.

The amount of catalyst is generally an effective amount that can produce an emulsion having the characteristics disclosed. It is also an amount, when a silicate is used, that can adjust the pH of the emulsion to 4.5 or less, preferably less than 2.2 such as about 2.0 depending on the catalyst. If an organosilane is used, there is no pH limitation. However, if a higher pH is desired, an aqueous alkali solution can be used to adjust the pH to 7.0 or more, especially 7.0-12.

The heat-resistant water-repellent characteristics of the coated layer produced from the emulsion composition can be effectively improved by either adjusting its pH to alkaline region or, if a silicate is used as the silicon-containing compound, acidifying to acidic region using, for example, phosphoric acid, boric acid, or combinations thereof.

The emulsion composition of the present invention can contain a pigment, a bactericide, an ultraviolet ray absorbent, an antioxidant, or other customarily used additives in a range without affecting the stability of the emulsion and the heat-resistant water-repellent characteristics of the coated layer.

Any methods known to one skilled in the art can be used for the preparation of the emulsion composition of the present invention. The components can be combined in any order to produce the composition.

However, it is preferable to dissolve a surfactant in water followed by addition of a fluorocarbon silane slowly, such that self-condensation of the fluorocarbon silane is inhibited and a hydrolyzed state of the fluorocarbon silane is maintained, with agitation such as stirring, any additives desired, the catalyst,

and finally the polymerizable, silicon-containing compound. Generally the pH is not appreciably affected by the addition of the silicon-containing compound. This process can be best used to inhibit self-condensation and to maintain a hydrolyzed state of the fluorocarbon silane.

The water-based emulsion of the present invention can be coated with or to any substrate. The substrates are rendered water-repellent, oil-repellent, or both characteristics by coating the emulsion on the substrate surface followed by drying. Examples of suitable substrates include, but are limited to, aluminum, stainless steel, or other metal sheets, glass, glass sheet, ceramic tile, brick, concrete, stone, wood, masonry, fiber, leather, plastics, or other substrate that can be used under high temperature conditions. The coating of the water-based emulsion on a substrate can be carried out by any methods known to one skilled in the art such as, for example, dipping method, spray method, spin coating method, roll coating method, or other publicly known methods. The dipping method is preferred because it does not cause damage to transparency on a glass substrate.

Heating can also be carried out in order to accelerate the drying process. In general, drying is carried out in a temperature range of about 100-350°C for about 5 minutes to 24 hours.

Furthermore, before coating the water-based emulsion of the present invention on a substrate, a silicone compound such as, for example, silica, can be coated to form a base or backing layer. By coating the emulsion on top of this layer, the heat-resistant water-repellent characteristics can be maintained for an prolonged period. The substrate after the coating with the emulsion composition, if necessary, can be washed with water after it is dried to remove the residual surfactant.

### EXAMPLES

The following examples are provided to illustrate the invention and are not to be construed as to unduly limit the scope of the invention.

The components used in the following application examples and comparative examples are as follows.

The fluorocarbon silane was a mixture of perfluoroalkyl silanes represented by  $R_f-(CH_2)_2-Si\{-(O-CH_2CH_2)_2-OCH_3\}_3$ , where  $R_f$  is

$F(CH_2)_kCH_2CH_2$  ( $k = 6, 1-2 \text{ wt\%}$ ;  $k = 8, 62-64 \text{ wt\%}$ ;  $k = 10, 23-30 \text{ wt\%}$ ; and  $k = 12-18, 2-6 \text{ weight \%}$ ). The surfactant was a nonionic surfactant represented by  $R_f'-CH_2CH_2-O-(CH_2CH_2O)_{11}-H$ , where  $R_f'$  is a perfluoroalkyl group having 3-18 carbon atoms, obtained from E.I. de Nemours & Company, Wilmington, Delaware. The silicate was tetrakis[2-(2-methoxyethoxy)ethyl] silicate ( $Si(DEGM)_4$ ). Organoalkoxysilane with the following formula of  $(CH_3)Si(OCH_3)_3$  (organomethoxysilane) was used. These chemicals were obtained from Kanto Chemicals Co., Inc., Japan.

#### 10 Application Example 1

The nonionic surfactant was dissolved in water so that its amount was 30 parts by weight with respect to 100 parts by weight of the fluorocarbon silane to produce a mixture. The fluorocarbon silane at 10 weight % based on the total weight of the water-based emulsion was slowly (2.1 kg was added over a 30 minute period) added to the mixture while stirred using a mechanical stirrer. Self-condensation of the fluorocarbon silane was inhibited and the hydrolyzed state was maintained. While the pH of the emulsion was being measured with a pH meter, phosphoric acid was added. When the pH reached 2.0, the addition of the phosphoric acid was stopped.  $Si(DEGM)_4$  was added such that the molar fraction of the  $Si(DEGM)_4$  with respect to the fluorocarbon silane was 0.45 to produce a water-based emulsion.

Then, after stirring the water-based emulsion for 2 to 4 hours, it was coated on an aluminum sheet (JIS 1100 with 2.5 cm x 5.0 cm, thickness 1 mm) to yield a test specimen.

25 The water-based emulsion was coated by dip coating. Dip coating was conducted by lowering the test specimen at a speed of 300 mm/min into the water-based emulsion, maintaining it in such a state for 5 minutes, and pulling it up at a speed of 50 mm/min. Drying after coating was carried out at 200°C for 60 minutes in an oven.

30 A drop of pure water (2  $\mu$ l) was placed on the coated layer surface of the test specimen. With a contact angle meter (Kyowa Interfacial Science, Japan), the contact angle was measured. The results are shown in Table 1.



The test specimen was placed in an oven at 375°C. After the time shown in Table 1 had elapsed, the contact angle was measured and is shown in Table 1.

### Application Example 2

5 In Application Example 2, a water-based emulsion containing a fluorocarbon silane hydrolysis product of the same composition as in Application Example 1 was prepared except that boric acid was used instead of the phosphoric acid and the pH was 4.0. A test specimen was prepared, and the same water-repellent test was carried out. The results for contact angles are shown in Table 1.

### 10 Comparative Examples 1 through 5

In Comparative Examples 1 through 5, water-based emulsions containing were prepared as in Application Example 1 except that hydrochloric acid, sulfuric acid, nitric acid, acetic acid, and formic acid were used, instead of the phosphoric acid, for adjusting the pH to 2.0. Test specimens were prepared, and the same

15 water-repellent tests were carried out. The results are shown in Table 1.

### Comparative Examples 6 through 9

In Comparative Examples 6 through 9, water-based emulsions were prepared as in Application Example 1 except that an aqueous ammonia solution, sodium hydroxide, potassium hydroxide, and pyridine were used (Table 1) instead

20 of phosphoric acid for adjusting pH to 8-11. Test specimens were prepared, and the same water-repellent tests were carried out. The results are shown in Table 1.

Table 1<sup>a</sup>

	App 1	App 2	Com 1	Com 2	Com 3	Com 4	Com 5	Com 6	Com 7	Com 8	Com 9
pH agent	PA	BA	HA	SA	NA	AA	FA	AH	SH	PH	Py
Final pH	2.0	4.0	2.0	2.0	2.0	2.0	2.0	10.8	11.2	11.0	8.1
IWRA	120	120	121	120	119	119	121	118	114	115	120
WRA-15	125	112	8	15	8	18	8	120	114	108	118
WRA-20	—	100	—	—	—	—	—	—	—	—	—
WRA-40	104	—	—	—	—	—	—	97	98	81	95

<sup>a</sup> The abbreviations used were: App, Application Example; Com, Comparative Example; PA, phosphoric acid; HA, hydrochloric acid; BA, boric acid; NA, nitric acid; AA, acetic acid; FA, formic acid; AH, aqueous ammonium hydroxide solution; SH, aqueous sodium hydroxide solution; PH, aqueous potassium hydroxide solution; Py, pyridine; pH agent denotes an acid or base used for adjusting pH of the emulsion; Final pH denotes to the final pH of the emulsion; IWRP denotes initial water-repellent angle (degrees); WRA-15 denotes water-repellent angle (degrees) after 15 hours

25

at 375°C; WRA-20 denotes water-repellent angle (degrees) after 20 hours at 375°C; and WRA-40 denotes water-repellent angle (degrees) after 40 hours at 375°C.

Comparing Application Examples 1-2 and Comparative Examples 1-5,  
5 coated layers having excellent water-repellent characteristics were obtained for all samples. However, when phosphoric acid or boric acid was used to adjust the emulsion to acidic region, the value of the water-repellent angle of the coated layer surface was about the same as, or higher than, that before aging after 15 hours at 375°C. This indicates that a coated layer had not only water-repellent  
10 characteristics alone but also heat-resistant, water-repellent characteristics.

Comparing Application Examples 1-2 and Comparative Examples 6-9,  
coated layers having excellent heat-resistant water-repellent characteristics were obtained for those emulsions adjusted to acidic region or alkaline region.  
However, the value of the water-repellent angle of the coated layer surface was  
15 more than 100° even after 20 or 40 hours at 375°C if phosphoric acid or boric acid were used. However, that those using an alkali solution as catalyst had value lower than 100. In other words, the coated layers containing phosphoric acid or boric acid had better durability of heat-resistant water-repellent characteristics than those containing an alkaline pH-adjusting agent. The results also show that  
20 the coated layer formed by coating the water-based emulsion of the present invention maintained excellent water-repellent characteristics even under high temperature conditions for a prolonged period.

#### Application Examples 3-5

Surfactant (30 parts by weight for 100 parts by weight of fluorocarbon  
25 silane) was dissolved in water. Fluorocarbon silane shown in Table 2 (10 weight % for the entire weight of water emulsion) was slowly added while using a conventional stirring method for stirring to inhibit fluorocarbon silane from self-condensation and to maintain fluorocarbon silane being hydrolyzed. While using a pH meter for measurement of the pH of the emulsion, an acid or pH-adjusting  
30 agent shown in Table 2 was added. The addition was stopped when a final pH shown in Table 2 was obtained.  $(\text{CH}_3)_3\text{Si}(\text{OCH}_3)_3$  was added to obtain molar ratio of  $(\text{CH}_3)_3\text{Si}(\text{OCH}_3)_3$  to fluorocarbon silane of 0.45 to make a water emulsion.

After the water emulsion was stirred for 2-4 hours, it was applied as coating on a glass plate (2.5 cm x 5.0 cm, thickness: 3 mm) to make a test sample.

A dip-coating method was used for the water emulsion. The test sample was dipped into the water emulsion at 300 mm/min, held for 5 minutes, and lifted up at 50 mm/min. After it was coated, it was dried at 200°C for 60 minutes in an oven to prepare a test sample.

Purified water (2 µl) was dripped onto the surface of coated layer of test sample. A contact angle was obtained by measurement using a contact angle meter (made by Kyowa Kaimen Kagaku, Japan). The results are shown in Table 2.

Kitchen oil (10 mg) was sprayed onto the surface of the coated layer of test sample, followed by baking at 250°C for 60 minutes. The burnt oil stain was wiped off 5 times with gauze, followed by visual observation to see how much burnt oil stain was removed. The results are shown in Table 2.

#### Comparative Examples 10-11

In Comparative Examples 1 and 2, water emulsion containing fluorocarbon silane hydrolyzate having the same composition as that of water emulsion obtained in Application Example 3 was prepared and a test sample was made, except tetrakis(2-(2-methoxyethoxy) ethyl) silicate (Si (DEGM)<sub>4</sub>) was used. The same water-repellency test and oil-stain resistance test were performed. The results are shown in Table 2.

#### Comparative Example 12

Both the same water-repellency test and same oil-stain resistance test performed in Application Example 3 were performed in Comparative Example 12. The results are shown in Table 2.

#### Comparative Examples 13-14

Water emulsion containing fluorocarbon silane hydrolyzate having the same composition as that in Application Example 3 was prepared except that no catalyst was used in Comparative Example 13 and that (Si(DEGM)<sub>4</sub>) instead of organomethoxysilane was used. Water-repellency and oil-stain resistance tests were carried out. The results are shown in Table 2.

Water emulsion containing fluorocarbon silane hydrolyzate having composition similar to that obtained in Application Example 3 was prepared in

Comparative Example 14 except that no catalyst was used. Water-repellency and oil-stain resistance tests were carried out. The results are shown in Table 2.

Table 2<sup>a</sup>

	App 3	App 4	App 5	Com 10	Com 11	Com 12	Com 13	Comp 14
Si	OMS	OMS	OMS	SiD	SiD	-	SiD <sub>4</sub>	OMS
PH agent	PA	HA	Am	PA	HA	-	-	-
Final pH	2.0	2.0	10.8	2.0	2.0	-	5.0	5.0
Substrate	Glass	Glass	Glass	Glass	Glass	Glass	Glass	Glass
PCA	120	120	119	120	119	121	119	118
DRBS	Comp	CompE	Comp	SR	SR	None	SR	SR

- 5 <sup>a</sup> See footnotes in Table 1 for abbreviations. Those not shown in Table 1 are Si, type of silicon compound; OMS, Organomethoxysilane; SiD, Si(DEGM)<sub>4</sub>; Am, ammonia; -, not present or measured; PCA, primary contact angle (degrees); and DRBS, degree for removal of oil stains (Comp, stains were almost completely removed; CompE, stains were essentially completely removed; SR, stains remained; and none, no stains were removed).

10 In Application Example 3, very small amounts of oil remained on the glass surface, but all oil could be easily and almost completely removed by wiping. In Application Example 4, oil was more difficult to remove by wiping than Application Example 3, but essentially all of burnt oil stain could be removed. Stains could be easily and almost completely removed in Application Example 5.

15 No burnt oil stain could be removed by wiping the surface of glass coated in Comparative Example 12. Oil was spread and remained on the surface of glass in Comparative Examples 10, 11, and 13 obtained with products containing silicate. Oil was spread and remained in Comparative Example 14 obtained with a product containing no pH-adjusting agent but organomethoxysilane.

20 The results show that the surface of coated layers with compositions containing organomethoxysilane or silicate exhibited good water repellency. Oil-stain resistance was considerably improved by using organomethoxysilane to with either an acid or a pH-adjusting agent. Using phosphoric acid further improved oil-stain resistance.

## 25 Application Examples 6-7

A water emulsion was prepared the same as Application Example 3, and applied as coating on a glass plate (2.5 cm x 5.0 cm, thickness: 3 mm) to form a test sample.

Purified water (2  $\mu$ l) was dripped on the surface of coated layer of test sample. A contact angle as obtained by measurement using a contact angle meter (made by Kyowa Kaimen Kagaku, Japan). The results are shown in Table 3.

- 5 Each test sample was placed in an oven at 330°C, the contact angle was measured similarly after 6 hours and after 10 hours aging. Results are shown in Table 3.

#### Comparative Examples 15-17

- 10 Each water emulsion was obtained in the same process used in Application Example 3, except for replacing organomethoxysilane with a silica compound shown in Table 3. It was applied as coating on a glass plate (2.5 cm x 5.0 cm, thickness: 3 mm) to obtain each test sample on which contact angle was similarly measured as in Application Example 6. Results are shown in Table 3.

Table 3<sup>a</sup>

	App 6	App 7	Com 15	Com 16	Com 17
Si	OMS	OMS	EpS	AS	ECS
pH	PA	HA	PA	PA	PA
Final pH	2.2	2.2	2.2	2.2	2.2
Substrate	Glass	Glass	Glass	Glass	Glass
PWRA	116	114	116	117	116
WRA-6	138	112	101	46	109
WRA-10	137	113	73	33	97

- 15 <sup>a</sup> See Tables 1 or 2 for footnotes. Those not shown in Table 2 are: EpS, epoxysilane; AS, aminnosilane; ECS, epoxycyclohexylsilane; PWRA, primary water-repellency angle (degree); WRA-6, water-repellency angle (degree) after 6 hours at 330°C; WRA-10, water-repellency angle (degree) after 10 hours at 330°C.

- 20 In Application Example 6, water-repellency angle on the surface of coated layer after 6 hours and after 10 hours at 330°C was better than that before aging, indicating that a coated layer having good water repellency at high temperature was obtained.

- 25 In Comparative Examples 15-17, a similar primary water-repellency angle obtained in Application Example 6 was obtained by a silicon compound other than organomethoxysilane, and that a coated layer having water repellency was obtained. However, each water-repellency angle after 10 hours at 330°C was

reduced, even phosphoric acid was used, and no coated layer had any water repellency at high temperature.

- Application Example 7, in which water emulsion containing organomethoxysilane was used as in Application Example 6, showed that a coated layer had good water repellency at high temperature even though hydrochloric acid was used as pH-adjusting agent.

#### Application Example 8

- Water emulsion was prepared similar to Application Example 3 and was coated on an aluminum plate (JIS1100 2.5 cm x 5.0 cm, thickness: 1 mm) to obtain a test sample.

Purified water (2  $\mu$ l) was dripped on the surface of coated layer of test sample. Contact angle was measured using a contact angle meter (made by Kyowa Kaimen Kagaku, Japan). The results are shown in Table 4.

- Each test sample was placed in an oven at 370°C and after 40 hours, the contact angle was similarly measured. Results are shown in Table 4.

#### Comparative Examples 18-21

- Each water emulsion was obtained the same as Application Example 3, except for using a silicon compound shown in Table 4. It was coated on an aluminum plate (JIS1100, 2.5 cm x 5.0 cm, thickness: 1 mm) to obtain test sample. A contact angle was measured as in Application Example 6. Results are shown in Table 4.

Table 4<sup>a</sup>

	App 8	Com 18	Com 19	Com 20	Com 21
Si	OMS	SiD	SiD	SiD	OMS
pH agent	PA	HA	PA	AH	-
Final pH	2.2	2.2	2.2	10.8	5.0
Substrate	Aluminum	Aluminum	Aluminum	Aluminum	Aluminum
PWRA	120	117	120	112	118
WRA-40 <sup>b</sup>	105	10	15	45	31

<sup>a</sup> See previous footnotes.

- <sup>b</sup> The temperature was 370°C.

Application Example 8 and Comparative Examples 18-21 had about the same primary water-repellency angles showing that each coated layer had good water repellency. However, Comparative Examples 18-20, in which silicate was used, had significantly reduced water-repellency angle after 40 hours at 370°C while Application Example 8 had water repellency of 105 degrees after 40 hours at 370°C. The results demonstrate that a coated layer having good water repellency at high temperature and good durability could be obtained using organomethoxysilane.

Comparative Example 21 had considerably reduced water-repellency angle after 40 hours at 370°C, indicating that even with use of organomethoxysilane, the lack of a catalyst failed to yield a good water-repellency at high temperature.

The above results show that a coated layer produced from water emulsions containing fluorocarbon silane or its hydrolyzate exhibits good water repellency at high temperature and good oil-stain resistance. A coated product made by applying water emulsion of the present invention was effective to remove oil stains easily, and can maintain good water repellency at high temperature.

CLAIMS

1. A composition comprising a fluorocarbon silane or hydrolyzate thereof; a  
 5 surfactant; a polymerizable, silicon-containing compound; and a catalyst wherein  
 said fluorocarbon silane has the formula of  $R_f-(CH_2)_p-Si\{-(O-CH_2CH_2)_n-OR'\}_3$ ,  $R_f$   
 is a  $C_{3-18}$  perfluoroalkyl group or combinations thereof, each  $R'$  is independently a  
 $C_{1-3}$  alkyl groups or combinations thereof,  $p$  is 2 to 4, inclusive, and  $n$  is 2 to 10,  
 inclusive; said silicon-containing compound is selected from the group consisting  
 10 of a silicate, an organosilane, and combinations thereof; and said catalyst is  
 phosphoric acid, boric acid, or combinations thereof if said silicon-containing  
 compound is said silicate.
2. A composition according to claim 1 wherein said silicon-containing  
 compound is a silicate having the formula of  $Si-R_4$ ,  $R$  is selected from the group  
 15 consisting of  $OCH_3$ ,  $OCH_2CH_3$ ,  $(OCH_2CH_2)_mOCH_3$ , and combinations thereof,  
 and  $m$  is 1 to 10, inclusive.
3. A composition according to claim 1 wherein said silicon-containing  
 compound is an organoalkoxysilane having the formula of  $R^2_qSi(OR^3)_{4-q}$ , each  $R^2$   
 is independently an alkyl group having 1 to 10 carbon number, each  $R^3$  is  
 20 independently an alkyl group having 1 to about 3 carbon number, and  $q$  is 1 to 3,  
 inclusive.
4. A composition according to claim 1, 2, or 3 wherein said fluorocarbon  
 silane is selected from the group consisting of perfluoroalkylethyltris(2-(2-  
 methoxyethoxy)ethoxy)silane, (2-(2-(2-methoxyethoxy)ethoxy)ethoxy)silane, and  
 25 combinations thereof.
5. A composition according to claim 1, 2, 3, or 4 wherein surfactant having a  
 HLB values greater than 12.
6. A composition according to claim 5 wherein surfactant having a HLB  
 values greater than 16.
7. A composition according to claim 5 or 6 wherein surfactants selected from  
 30 the group consisting of  $R'_f-CH_2CH_2-O-(CH_2CH_2O)_{11}-H$ ,  $C_9H_{19}-C_6H_4-O-$   
 $(CH_2CH_2O)_{50}-H$ ,  $R'_f-CH_2CH_2SCH_2CH(OH)CH_2N(CH_3)_3^+Cl^-$ ,



$C_{12}H_{25}(OCH_2CH_2)_4OSO_3NH_4^+$ ,  $C_{12}H_{27}-C_6H_4-SO_3-Na^+$ , and combinations thereof, and  $R_f'$  is a perfluoroalkyl group having about 3 to about 18 carbon atoms.

8. A composition according to claim 1, 2, 4, 5, 6, or 7 wherein said silicon-  
5 containing compound is  $Si-((OCH_2CH_2)_2OCH_3)_4$ .
9. A composition according to claim 1, 2, 3, 5, 6, or 7 wherein said silicon-  
containing compound is organomethoxysilane.
10. A composition according to claim 1, 2, 4, 5, 6, 7, or 8 wherein said  
catalyst is an acid selected from the group consisting of phosphoric acid, boric  
10 acid, and combinations thereof.
11. A composition according to claim 1, 2, 3, 5, 6, 7, or 9 wherein said  
catalyst is selected from the group consisting of phosphoric acid, boric acid,  
hydrochloric acid, sulfuric acid, nitric acid, acetic acid, oxalic acid, ammonia,  
pyridine, sodium hydroxide, or potassium hydroxide, and combinations thereof.
12. A process comprising dissolving a surfactant in water to produce a  
15 surfactant-water mixture; combining said surfactant-water mixture with a  
fluorocarbon silane to produce a silane-surfactant mixture; combining said silane-  
surfactant mixture with a catalyst to produce a pH-adjusted mixture; and  
combining said pH-adjusted mixture with polymerizable, silicon-containing  
20 compound to produce an emulsion wherein said surfactant, said fluorocarbon  
silane, said catalyst, and said silicon-containing compound are as recited in any  
of the preceding claims.
13. A process comprising contacting a substrate surface with a composition  
wherein said composition is as recited in any of claims 1 to 11 and said substrate  
25 is metal, glass, ceramic tile, brick, concrete, wood, masonry, fiber, leather,  
plastics, or stone.